

Work Order ID 146382

July 28, 2016 8:54:22 AM

146382

Reprint

Page 1

Item ID: D2512-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 5/17/2016 Start Qty: 4.00

4 6 SA
4 6

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 4.00

Customer:

Reference:

Approvals:

Process Plan: SA

Date: 7/28/16

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D2512	G

100

0.00

100

Large Fab

Large Fab

Memo

0.88

Large Fab

1- Cut as per dwg D2512

2- Deburr and remove identification markings on tube

6 C 16-07-28

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Memo

0.00

Quality Control

DAS
43
9-89

JUL 28 2016

120

Identify as per dwg & Stock Location: WWP 04

0.00

120

Packaging

Memo

0.04

Packaging

LOCATION WA004

DAS
43
9-89

JUL 28 2016

6x

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : ☐					

Work Order ID 146382

146382

Page 2

July 28, 2016 8:54:22 AM

Item ID: D2512-3

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Rib

Start Date: 5/17/2016 Start Qty: 4.00

4

Cust Item ID:

Required Date: 5/20/2016 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

DAS
21

AUG 04 2016

QC

Memo

0.40

Quality Control

DEM 10/07/29

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Picklist Print

July 28, 2016 8:54:32 AM

Page 1

Work Order ID: 146382

146382

Parent Item: D2512-3

D2512-3

Parent Item Name: Rib

Start Date: 5/17/2016

Required Date: 5/20/2016

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV:A 12.07.27 AS PER DWG REV.F DD VERF:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304TS0.750W.065

Purchased

No

100

f

914.6100

7.942

33.44

M304TS0 750W 065

304 SQ Tube .75x.75x.065W

**

34' C 16-07-28

Location

Loc Qty

Loc Code

WA004

914.61

m132270

35.88

m133412

482

m133757

54.73

m134696

142

m135231

200

8 7 6 5 4 3 2 1

D

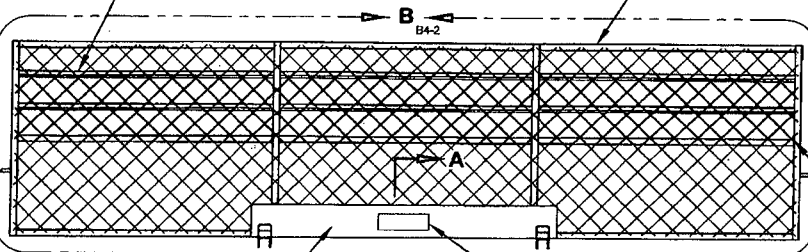
C

B

A

SKIN OUTSIDE SURFACE OF LID
WITH D3832-13, TACK WELD
EACH END STRAND TO FRAME

SEE DETAIL B FOR
FRAME ASSEMBLY

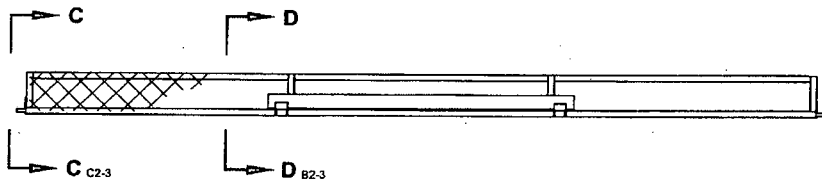


D2506 LABEL PLATE
CENTER ON THE BASKET

REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

FINISH THIS SECTION ALONG
ENTIRE LENGTH PER NOTE 2
AFTER POWDER COAT.

TACK WELD MESH TO FRAME
AT EVERY AVAILABLE LOCATION
IN AREA TO BE ANTI-SKIDDED



C C-2-3

D D-2-3

D3833-7
TYP, BOTH ENDS



D2512 BASKET LID ASSEMBLY NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT ENTIRE ASSEMBLY WHITE (4.3.5.2) PER DART QSI 005 4.3
AFTER POWDER COAT, SPRAY PAINT BLACK INSIDE SURFACE AND
APPLY BLACK ANTI-SKID TO OUTSIDE SURFACES PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004

QTY	PART NUMBER	DESCRIPTION
X	D2512	BASKET LID ASSEMBLY
2	D2512-3	RIB
6	D2512-5	RIB
3	D2512-7	RIB
2	D2232-1	HINGE PLATE
4	D2236	RIB
1	D2506	LABEL PLATE
2	D2581	MOUNTING BRACKET
2	D3825-043	RIB ASSY (BASKET END, LID)
1	D3832-13	MESH (LID)
2	D3833-7	MESH, LID END

G

D

C

B

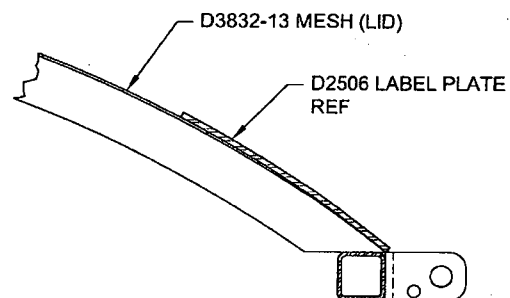
A

RELEASED
2012-00-03

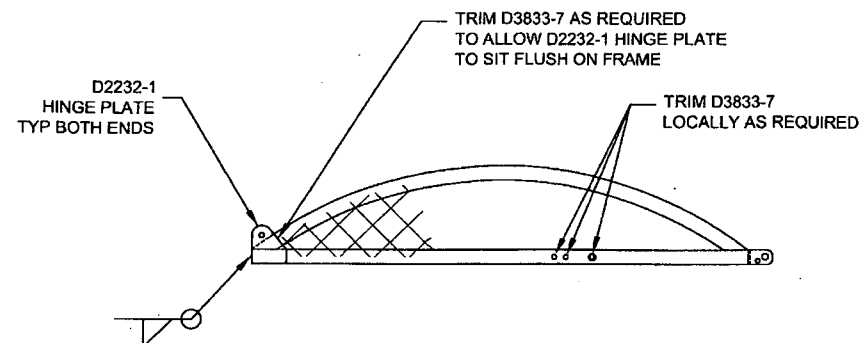
7/28/16
SH 140382

G	CORRECTED TYPO: D3825-043 WAS D3825-041 (ZN D3-1, B8-2, B1-2)	MB	12.07.26
F	GENERAL REVISION; REFORMATED DWG; DELETED DETAIL E AND RELATED NOTES IN VIEW C-C. REASON: PAR10-50.	MB	12.05.11
E	INCORPORATED D1 & D2. MATERIAL FOR -1, -3, -5, & -7 WAS 0.060 WALL. SHIT 3 ZN C4 TOLERANCE REMOVED FROM 95.30 DIM. DRAWING TRANSFERRED TO "B" FORMAT AND UPDATED TO CURRENT STANDARDS. SHIT 3 VIEWS INVERTED FOR CLARITY. SHIT 2 MESH MATERIAL CALLOUT UPDATED.	AJS	08.06.17
D	CHANGE HINGE	CP	01.04.19
C	REMOVE DOUBLE SKIN SECTION, ADDED MEMBERS, INCORP DEO 9074	DS	99.07.06
B	ADDED LATCH CHANNEL & LABEL PLATE	BW	96.05.24
A	NEW ISSUE	BW	95.11.21
REV.	DESCRIPTION	BY	DATE
DESIGN	BW	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ASS	DRAWING NO.	REV. G
CHECKED	ASS	D2512	SHEET 1 OF 4
MFG. APPR.	IMP	TITLE	SCALE
APPROVED	IMP	BASKET LID ASSEMBLY (350/212)	NTS
DE APPR.			
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. IT IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

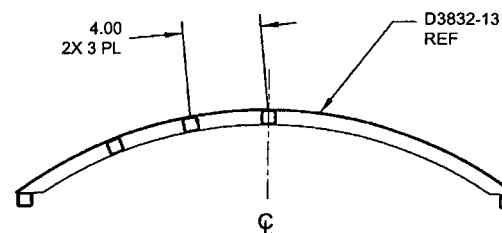
8 7 6 5 4 3 2 1



SECTION A-A
(ROTATED 90° CCW)



VIEW C-C SIMILAR BOTH END RIBS B8-1



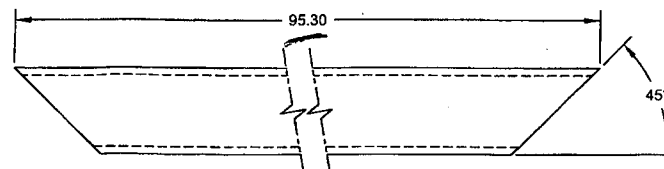
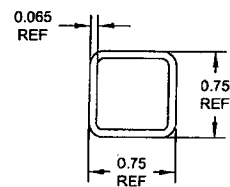
SECTION D-D SAME BOTH CENTER RIBS B7-1

RELEASED
2012-08-03
JMP

DESIGN	BW	DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. G
MFG. APPR.	JMP	D2512	SHEET 3 OF 4
APPROVED	JMP	TITLE	SCALE
DE APPR.	JMP	BASKET LID ASSEMBLY (350/212) NTS	
DATE	12.07.26	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
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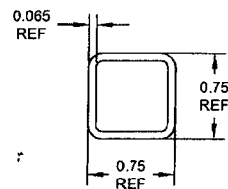
8 7 6 5 4 3 2 1

D



D2512-3 RIB

C



D2512-X RIB

DART PART NUMBER	L
D2512-5	30.84
D2512-7	30.63

RELEASED
2012-08-03

D2512-5/-7 NOTES:

- 1) MATERIAL: AISI 304/316 SEAMLESS STAINLESS STEEL SQUARE TUBING
PER ASTM A554/A269 MILL FINISH, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC M304TS0.750W.065
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

DESIGN	BW	DART AEROSPACE LTD
DRAWN	R	HAWKESBURY, ONTARIO, CANADA
CHECKED	ASS	DRAWING NO. D2512
MFG. APPR.		REV. G
APPROVED		SHEET 4 OF 4
DE APPR.		TITLE BASKET LID ASSEMBLY (350/212)
DATE	12.07.26	SCALE NTS

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8 7 6 5 4 3 2 1